

Work Order ID 52934

October 19, 2009 11:02:14 AM



Page 1

Item ID: D3991-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Packer

Start Date: 10/19/09 Start Qty: 8.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: RF

Date: 09-10-19

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3991

A

100

0.00



Waterjet

0.00

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3991

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

= 7 m. l 09/11/02

25X

25

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-10-30

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Customer:




Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	2) Sordulor			count X25	4		
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	MD 09/11/03			X25			
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	H 09/11/03			X25	0		

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Required Date: 11/02/09 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>139</u> Memo	0.00 0.00							
160 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

09/11/03 (25)

09/11/04 *HJ*
ME
09-11-04

Picklist Print

October 19, 2009 11:02:18 AM

Page 1

Work Order ID: 52934

Parent Item: D3991-3RevA-PRELIM

Parent Item Name: Packer

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	156.9479	0.1600	.5.		



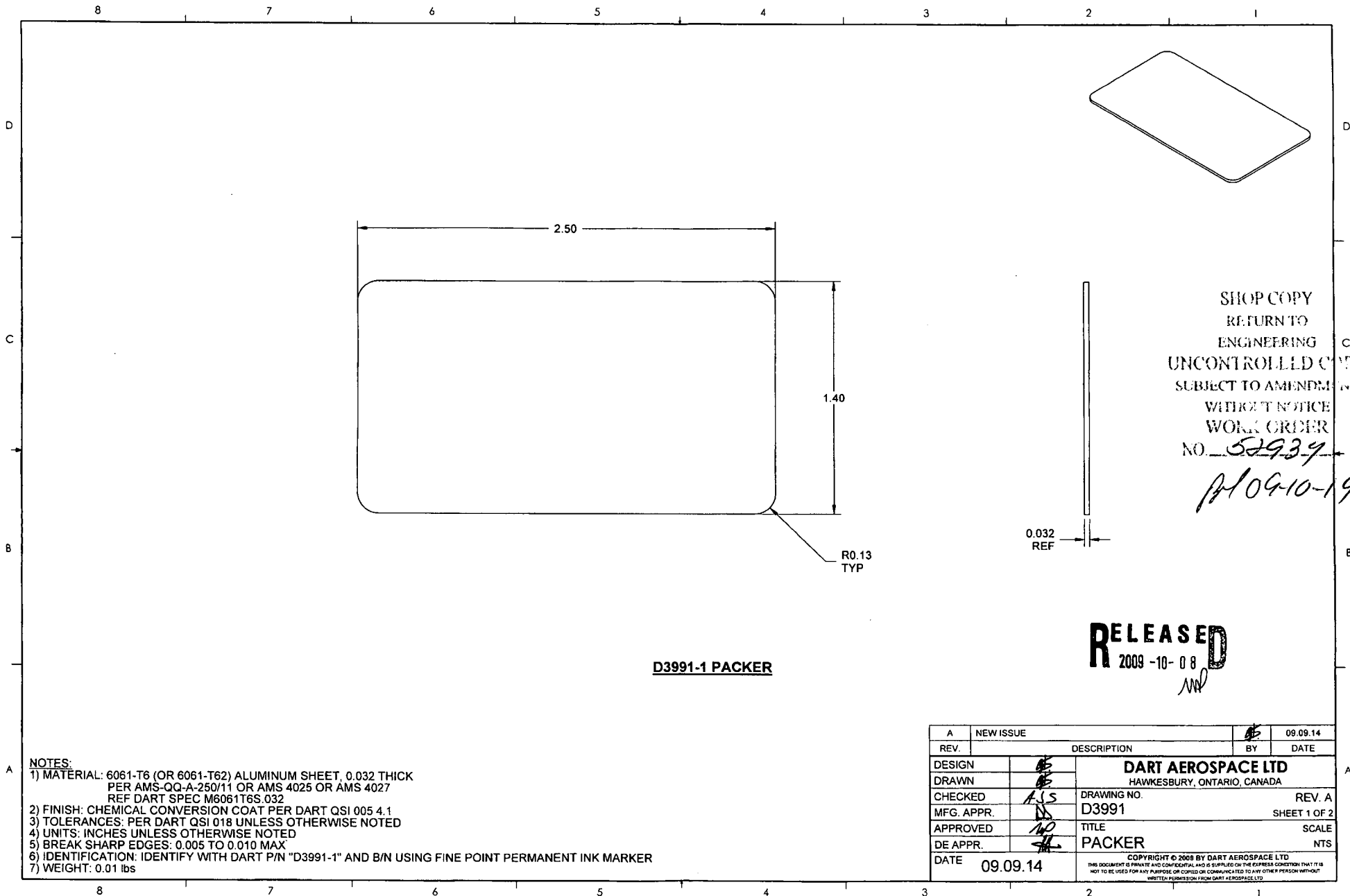
6061-T6 Sheet 0.032"

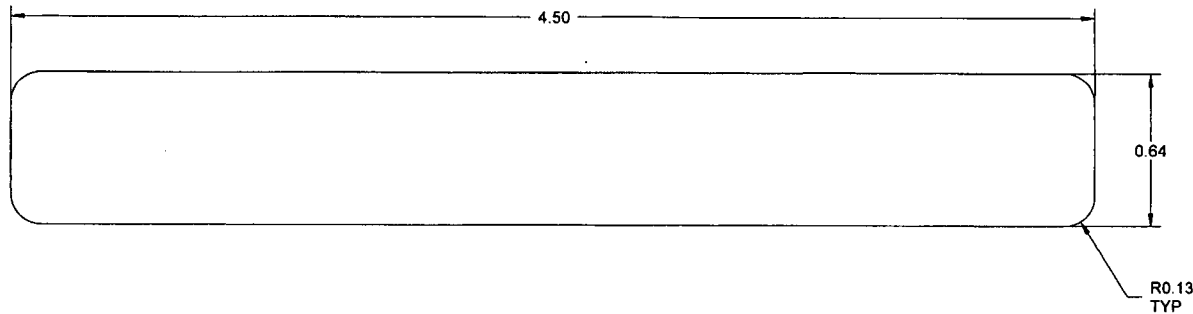


IB 9-10-30

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	156.9479	
110063	0.859	
112763	96	
16954	8.99	
18375	51.0989	

116663





D3991-3 PACKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52934

RELEASED
2009-10-08
ND

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3991-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

DESIGN	<i>AS</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AS</i>	D3991	SHEET 2 OF 2
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	PACKER	NTS
DATE	09.09.14	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	